



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G08832-3G
Job Sheet 172623



Part No: RBW6405G08832-3G

Job Qty: 3 ea

Mar 23

04/30

Part Name: Tail Rotor Bushing Install Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G08832-3G REV.D IPP Rev.A 17.09.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	4/30/18	4/30/18	0.00	0.00	Start Up Small Fab-4		
92	Purchasing	3 pcs	4/30/18	4/30/18	0.00	0.00	Outsourcee5 <i>Purchasing</i>		<i>At 18/05/02</i>
94	Packaging	3 pcs	4/30/18	4/30/18	0.00	0.00	Packaging2		<i>At 18/05/02</i>
96	QC	3 pcs	4/30/18	4/30/18	0.00	0.00	QC6		<i>38</i>
140	Packaging	3 pcs	4/30/18	4/30/18	0.00	0.00	Packaging3-1		<i>MAY 0 2 2018</i>
150	QC21-SA	3 Ea	4/30/18	4/30/18	0.00	0.00	QC21		<i>MAY 0 2 2018 GA097</i>

Part Op 92 - 1- Issue P/O to Arrow Tech Machine Works P/O# *039084* 2- Manufacture RBW6405G08832-3G as per
Descriptions: DWG 3- Certificate of conformity is required

DAS 21 3-20

0.00

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G08832-3GP	Tail Rotor Bushing Install Tool	3 (1 ea)	90-Start up Operation	<i>5067414</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G08832-3GP	3	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S067536

Tail Rotor Bushing Install Tool

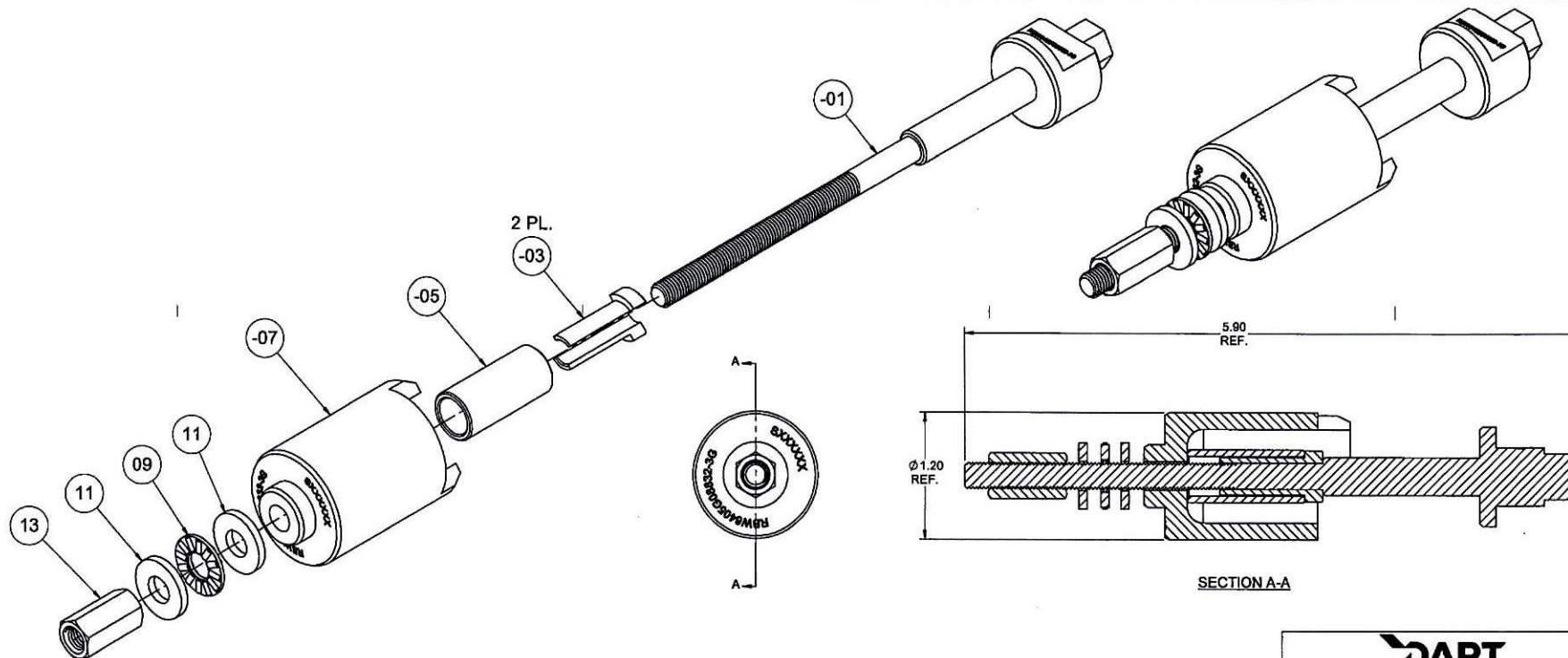
RBW6405G08832-3G

PART NO:
Serial No/Batch: S067536
Revision:
Operation:
Change No:
Packaging

Mfg Date: 05/02/18
Job No: 172623

ITEM #	QTY	PART #	TITLE	PG
-01	1	RBW6405G08832-3G-01	INSTALL ROD	2
-03	2	RBW6405G08832-3G-03	KEEPERS	3
-05	1	RBW6405G08832-3G-05	LOCK TUBE	4
-07	1	RBW6405G08832-3G-07	RECEIVER	5
09	1	TIMKEN NTA-411	THRUST BEARING 1/4" ID	-
11	2	TIMKEN TRC-411	TRUST WASHER 1/4" ID.	-
13	1	MSC#64828082	COUPLING NUT 1/4"-28 UNF	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
A	SHT 1 CHANGED QTY MADE FROM 2 TO 4 ITEM-03, -05 CORRECTED WALL THK. SHT 3 ADDED TOL ON Ø.250 PER GE SHT 5 CORRECTED T/N ENGRAVE NOTE.	-	3-11-11	JAG	DW
1	CHD -05 O.D. FROM Ø.498 [12.6mm] PER S.E.	-	3-11-11	RJC	SE
1A	-7 CHD MATERIAL WAS 6061 IS 7075. -11 CHD B.O. WAS TIMKEN TRA-411 IS TIMKEN TRC-411.	-	3-12-13	BIM	DW
2	-07 CORRECTED .04in (1mm) X 30 (X2) CHAMFER ORIENTATION ON 1.20in TO MATCH ORIENTATION ON THE .59in.	-	7-31-13	RJC	GE
D	TOLERANCES ADDED ON SHEET 2 & 3, TEMPLATE UPDATED, 04 x 45° CMF ADDED ON SHEET 1, ENGRAVE P/N CHANGED ON SHEET 2 & SHEET 5, -05 CHANGE MATERIAL TO ALUMINIUM	17-693	17.11.10	VM	WM



RBW6405G08832-3G TAIL ROTOR BUSHING INSTALL TOOL

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A
- 7) USED IN KIT RBW6405G08832-3G

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE TAIL ROTOR BUSHING INSTALL TOOL	
DWG NO. RBW6405G08832-3G	REV D
DESIGN BY: VM 10/3/2017	CHK VM 10/3/2017
DRAWN BY: VM 11/08/2017	CHK VM 11/08/2017
CHECKED: SAC 11/08/2017	CHK SAC 11/08/2017
MFG. APPR: DD 11/08/2017	CHK DD 11/08/2017
APPROVED: VM 11/10/2017	CHK VM 11/10/2017
DATE: 11/8/2017	CHK 11/8/2017
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 5	
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PURCHASE ORDER **P0039084**

Dart Aerospace Ltd.
 1270 Aberdeen St
 Hawkesbury, ON
 K6A 1K7
 Canada
 Tel (613) 632-5200



Supplier:

ARR002-VU
 Arrow Tech Machine Works
 29751 E. Enid Road,
 Eugene, OR 97402 USA
 Phone: 541-780-6938
 Fax: 458-215-4938

Ship To:

PO No: P0039084
PO Date: 2/21/18
Due Date: 4/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Baker, DianePhone: dbaker@dartaero.com
Freight Terms: Net 30
Special Comments:

E-MAILED
 MAR 06 2018

Line	Item	Part	Supplier	Part No	Description	Status	Due	Order	Received	Balance	Unit	Extended
							Date	Quantity	Quantity		Price (USD)	Price

1		RBSC7028-PP			Portable Bearing Cutter As Per Dwg RBSC7028-P Rev.6	Firmed	4/6/18	7 pcs	0 pcs	7 pcs	\$843.42/pcs	\$5,903.94
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2		RBET03A94-3000-00-1P			Wide Frame Assembly As Per Dwg RBET03A94-3000-00-1 Rev. 1	Firmed	3/20/18	3 Ea	0 Ea	3 Ea	\$2,417.56/Ea	\$7,252.68
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3		RBET03A94-3000-00-3P			Narrow Frame Assembly As Per Dwg RBET03A94-3000-00-3	Firmed	3/20/18	3 Ea	0 Ea	3 Ea	\$2,417.56/Ea	\$7,252.68
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4		RBW0805G00231-3GP			Adapter Assembly Helicopter Weighing As Per Dwg RBW0805G00231-3G-1	Firmed	4/30/18	9 Ea	0 Ea	9 Ea	\$564.82/Ea	\$5,083.38
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5		RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/D	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$809.13/Ea	\$2,427.39
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6		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$459.38/Ea	\$1,378.14
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7						Firmed	4/16/18	5 Ea	0 Ea	5 Ea	\$618.50/Ea	\$3,092.50
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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039084

Dated: 04/27/2018

Our Order / Job No: 26AWT

Order Qty: 3

Part Name: Tail Rotor Bushing Install Tool

Part Number: RBW6405G08832-3G

Lot Size:N/A

Ship Date: 04/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6405G08832-3G

Rev:D

Material Size and Type: -1 AND -3/4 140 Q&T STEEL;-5 AND -7/7075 -T6 ALUM.

Material Specifications: STEEL-ASTM A108, ASTM A29; ALUM. - ASTM B211 -T6

Heat Treatment: 28-32 RC

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS 1; ZINC PLATE: ASTM B633, TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

04/27/18

Signed:

DAc
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MAY 02 2018

PHGE Machine Works LLC dba Arrow Tech Machine Works
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www.atechmachineworks.com